



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4681-041

Job Sheet 177510



Part No: D4681-041

Job Qty: 2 ea

Part Name: Web Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/14/18

Job Tracking No:

Created By: Michelle Gagnon-Donovan

Due Date: 5/30/18

Description:

Type: SOLD

Note: DWG REV B SHEETS 1,2 IPP REV:A 13.04.15 NEW ISSUE DD VERF:JLM IPP REV:B 13.08.08 PB1 DD VERF:JLM IPP REV:C 13.11.14 AS PER DWG REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		5/30/18	0.00	0.00	Start Up Skid tubes-2		JLS
110	Skid tubes	2 pcs		5/30/18	0.00	1.72	Skid tubes-2		SA
120	QC	2 pcs		5/30/18	0.00	0.00	QC6		BE
121	CNC Vertical Machining	2 pcs		5/30/18	0.18	1.32	HAAS1-5		BE
122	QC	2 pcs		5/30/18	0.00	0.00	QC2 Machining-3		WJH
123	QC	2 pcs		5/30/18	0.00	0.00	QC8 Machining-3		WJH
130	HandFinish	2 pcs		5/30/18	0.00	0.56	HandFinish1		SA 18-05-15
140	QC	2 pcs		5/30/18	0.00	0.00	QC7-4		BE
150	Skid tubes	2 pcs		5/30/18	0.00	1.72	Skid tubes-3		JLS
160	QC	2 pcs		5/30/18	0.00	0.00	QC5		BE
170	Packaging	2 pcs		5/30/18	0.00	0.00	Packaging3-2		BE
180	QC21-SA	2 Ea		5/30/18	0.00	0.00	QC21		WJH 18/05/17

Part Op 110 - 1 CUT TO LENGHT AS PER DWG

Descriptions: 121 - MILL AS PER DWG AND FOLIO FB186 DWG REV: FOLIO REV: DEBURR

150 - INSTALL DOUBLER BY REVITING AND SEALING FAYING SURFACE WITH PROSEAL AS PER DWG A/R

PROSEAL: 138 384

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2963-125	105 I-Beam Extrusion	2 Ea (1 ea)	90-Start up Operation	156 870
D4681-3	Doubler	4 Ea (2 ea)	150-Skid tubes	128 552
MS20470AD4-6	Rivet, Universal Head	178 Ea (89 ea)	150-Skid tubes	5041165

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2963-125	2	130	0
150-Skid tubes	D4681-3	4	8	0
	MS20470AD4-6	178	3,484	0



Container No: S071144



Part: D4681-041

Job No: 177510

Serial No/Batch: S071144

Revision: b

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/14/18

5/14/2018

[Dart Hawkesbury] Job Sheet - Gagnon-Donovan, Michelle

Part Specifications
Specifications could not be found.

Plex 5/14/18 11:41 AM Dart.Gagnon.Michelle

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SUBJECT TO AMENDMENT

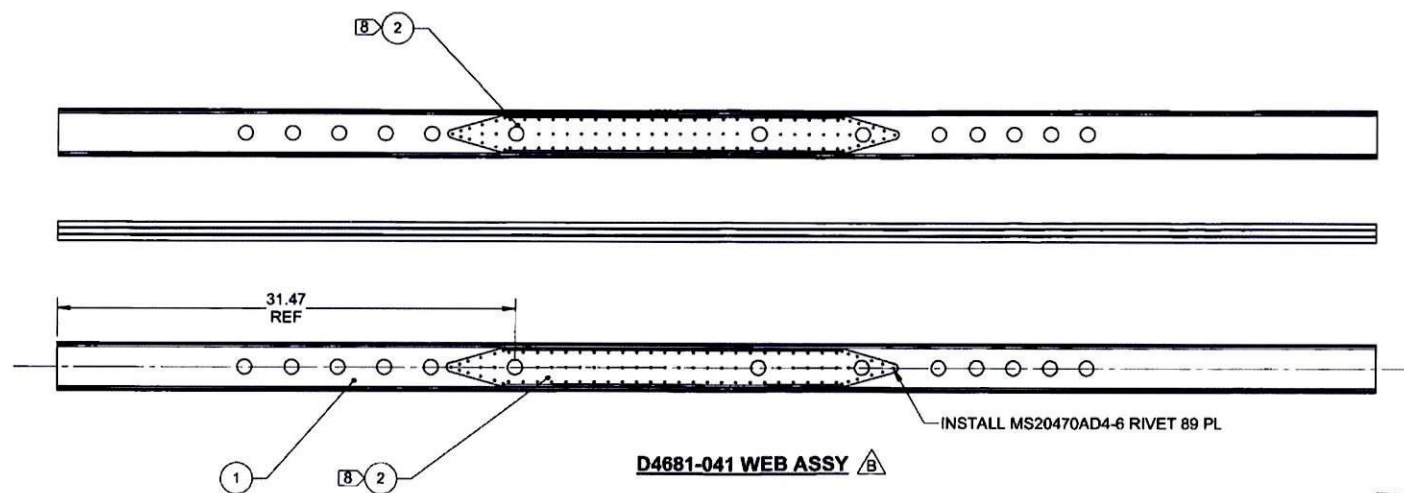
WITHOUT NOTICE

WORK ORDER

NO. 177510

MAY 14 2018

ITEM	QTY	P/N	DESCRIPTION
	X	D4681-041	WEB ASSY
1	1	D4681-1	WEB
2	2	D4681-3	DOUBLER
3	89	MS20470AD4-6	RIVET, PAN HEAD

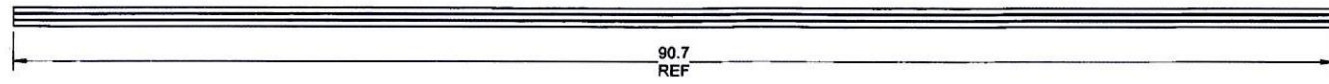
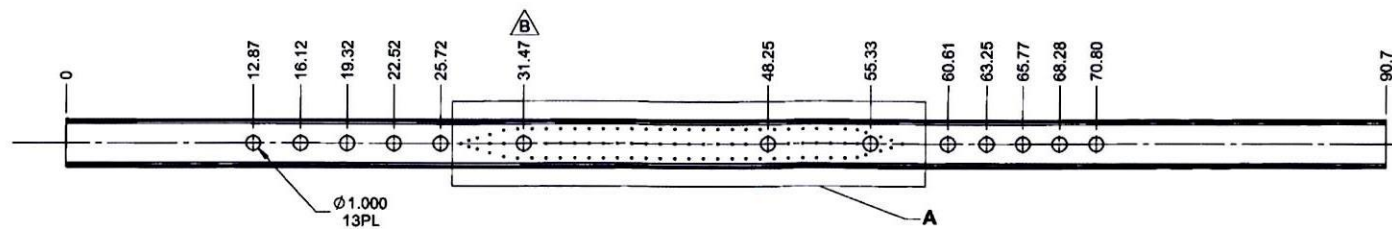


NOTES:

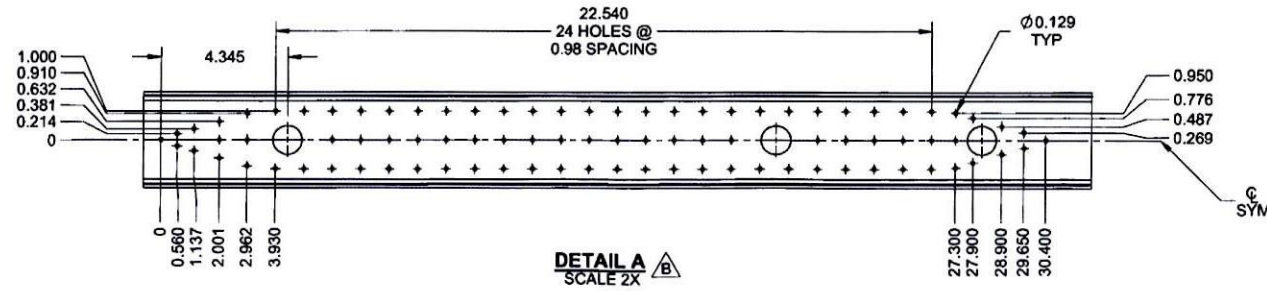
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4681-041" AND B/N PER QSI 044 METHOD 6.1
- 7) WEIGHT: 5.94 lbs
- 8) SEAL FAYING SURFACES WITH PROSEAL P/S 890 B-1/2 (PRC)

B	MS20470AD4-6 WAS MS20470AD4-7, ADDED DETAIL A ON SHEET 2, VARIOUS DIMENSIONAL CHANGES.		AP	13.08.08
A	NEW ISSUE		AP	13.02.13
REV.	DESCRIPTION		BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA		
DRAWN	AP			
CHECKED	ALS	DRAWING NO.	REV. E	
MFG. APPR.	2/	D4681	SHEET 1 OF 4	
APPROVED	2/	TITLE	SCALE	
DE APPR.	2/	WEB ASSY	NTS	
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8 7 6 5 4 3 2 1



D4681-1 WEB



DETAIL A
SCALE 2X

RELEASE
2013-11-13

- NOTES:
- 1) MATERIAL: MAKE FROM D2963-092 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 4.74 lbs

DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	ALS	DRAWING NO.	REV. B
MFG. APPR.	2/1	D4681	SHEET 2 OF 4
APPROVED	1/2	TITLE	SCALE
DE APPR.	1/2	WEB ASSY	NTS
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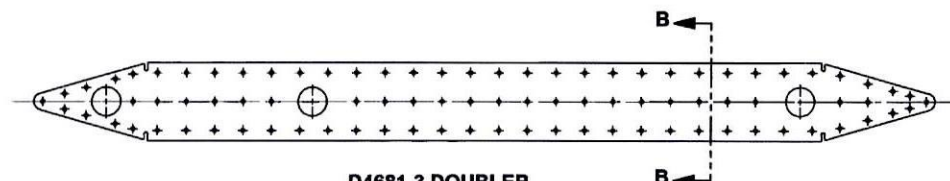
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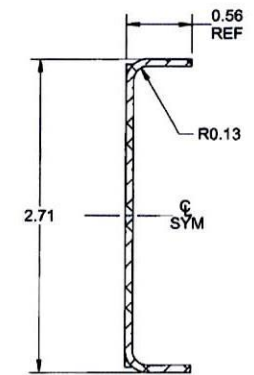
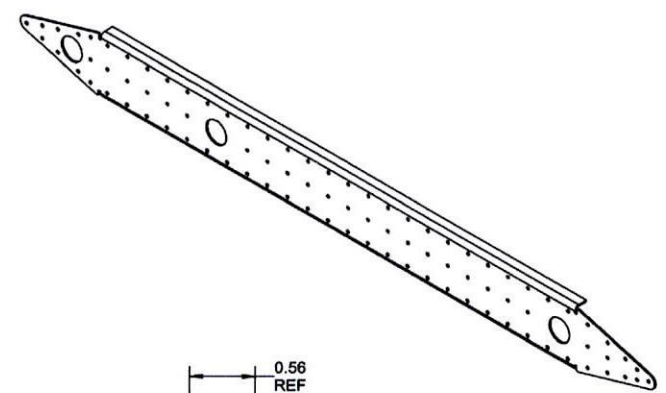
C

B

A



D4681-3 DOUBLER



SECTION B-B
SCALE 4X

RELEASED
2013-11-13
WMP

NOTES:

- 1) MATERIAL: MAKE FROM D4681-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: .56 lbs

DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	ALS	DRAWING NO.	REV. B
MFG. APPR.	DS	D4681	SHEET 3 OF 4
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8 7 6 5 4 3 2 1

